**Dart Aerospace Ltd.**

Date: Monday, 2/19/2007 8:59:46 AM
User: Kim Johnston

# Process Sheet

| | | | |
|---|---|---|---|
| **Customer** | : CU-DAR001 Dart Helicopters Services | **Drawing Name** | : WEARSHOE |
| **Job Number** | : 30760 | | |
| **Estimate Number** | : 12740 | | |
| **P.O. Number** | : N/A | **Part Number** | : D353523 |
| **This Issue** | : 2/19/2007 **S.O. No.** : N/A | **Drawing Number** | : D3535 UNDER REVIEW Rev A PH 07.02.19 |
| **Prsht Rev.** | : NC | **Project Number** | : N/A |
| **First Issue** | : N/A **Type** : SMALL /MED FAB | **Drawing Revision** | : U/R |
| **Previous Run** | : N/A | **Material** | : N/A |
| **Written By** | : | **Due Date** | : 2/26/2007 **Qty:** 12 13 **Um:** Each |
| **Checked & Approved By** | : PH 07.02.19 | | |
| **Comment** | : Est Rev:A New Issue 07-02-15 JLM | | |

**Additional Product**

Job Number:

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 1.0 | M304S20GA | 304/316 .040 Sheet |

**Comment:** Qty.: 1.4296 sf(s)/Unit Total : 17.1549 sf(s)
304/316 .040 Sheet
(M304S20GA)
Batch: M101873 SAD 07/02/25

| | | |
|---|---|---|
| 2.0 | WATER JET | FLOW WATER JET |

**Comment:** FLOW WATER JET
1-Cut as per Dwg D3535
Dwg Rev: A
Prog Rev: A SAD 07/02/25
2-Deburr if necessary 13

| | | |
|---|---|---|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE SAD 07/02/25 13

| | | |
|---|---|---|
| 4.0 | QC8 | SECOND CHECK |

**Comment:** SECOND CHECK 13

| | | |
|---|---|---|
| 5.0 | BRAKE NC | NC BRAKE |

**Comment:** NC BRAKE
1-Form on Brake as per Dwg D3535 using Jigs DT8261and DT8326
2-Form joggle as per Dwg D3535 using Jig DT8158
3-Identify as D3535-23
MF. 07-03-05
SB 07/03/06 13



Form: process

**Dart Aerospace Ltd**

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes (No) **DQA:** AD **Date:** 07/03/08

**QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

Date: Monday, 2/19/2007 8:59:46 AM
User: Kim Johnston

# Process Sheet

**Customer:** CU-DAR001 Dart Helicopters Services **Drawing Name:** WEARSHOE

**Job Number:** 30760 **Part Number:** D353523

Job Number:

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 6.0 | QC5 | INSPECT WORK TO CURRENT STEP |
| | **Comment:** INSPECT WORK TO CURRENT STEP | 07/03/07 (13) |
| 7.0 | POWDER COATING | POWDER COATING |
| | **Comment:** POWDER COATING<br>Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 | M101601<br>MJ / M-K 07-03-07 (13) |
| 8.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |
| | **Comment:** INSPECT POWDER COAT/CHEMICAL CONVERSION | a.m 07/03/07 (13) |
| 9.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
| | **Comment:** PACKAGING RESOURCE #1<br>Identify and Stock<br>Location: FI | MJ 07-03-07 (13) |
| 10.0 | QC21 | FINAL INSPECTION/W/O RELEASE |
| | **Comment:** FINAL INSPECTION/W/O RELEASE | (13)<br>07/03/08 |

Job Completion

M 07/03/08

**Dart Aerospace Ltd**

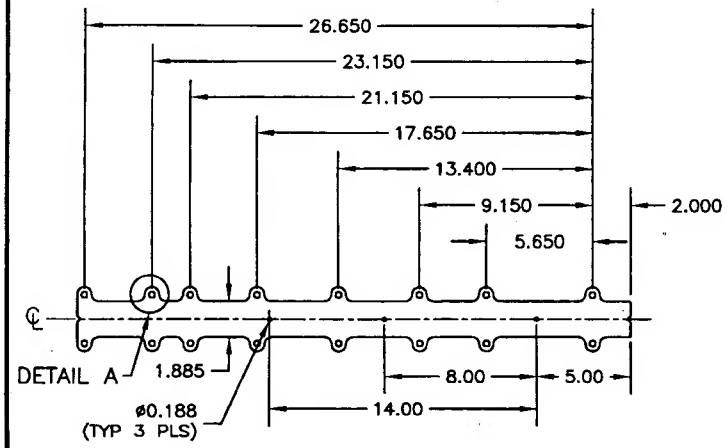
| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

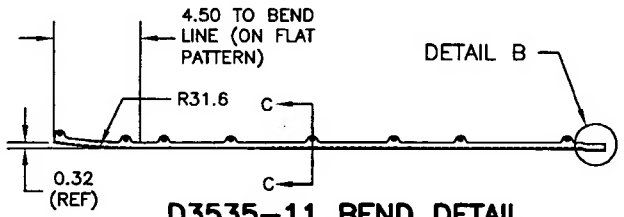
**QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries




## D3535-11F FLAT PATTERN




## D3535-11 BEND DETAIL

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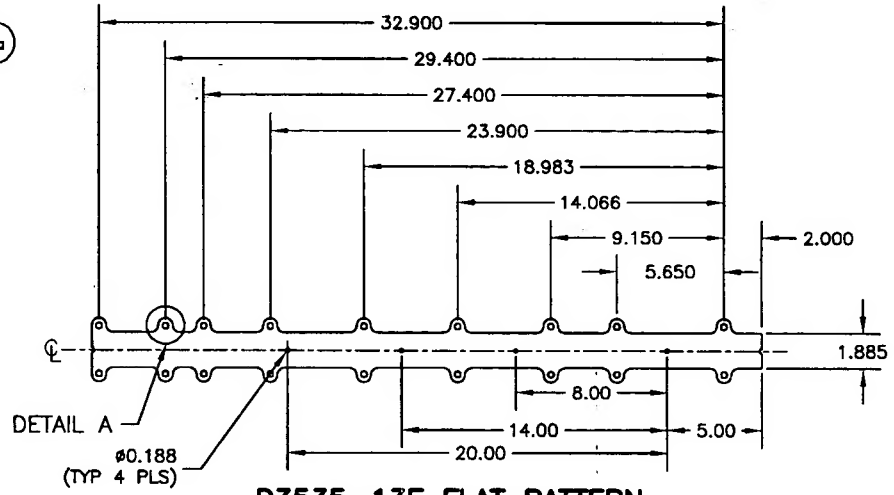
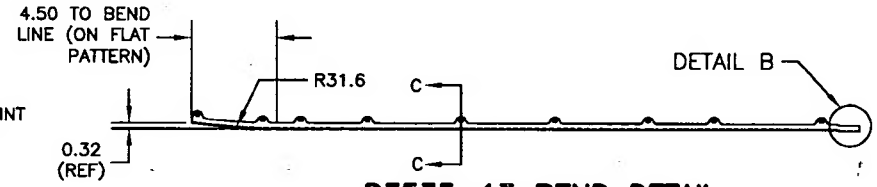
WITHOUT NOTICE
WORK ORDER
NO. 30760




## D3535-13F FLAT PATTERN




## D3535-13 BEND DETAIL

**NOTES**

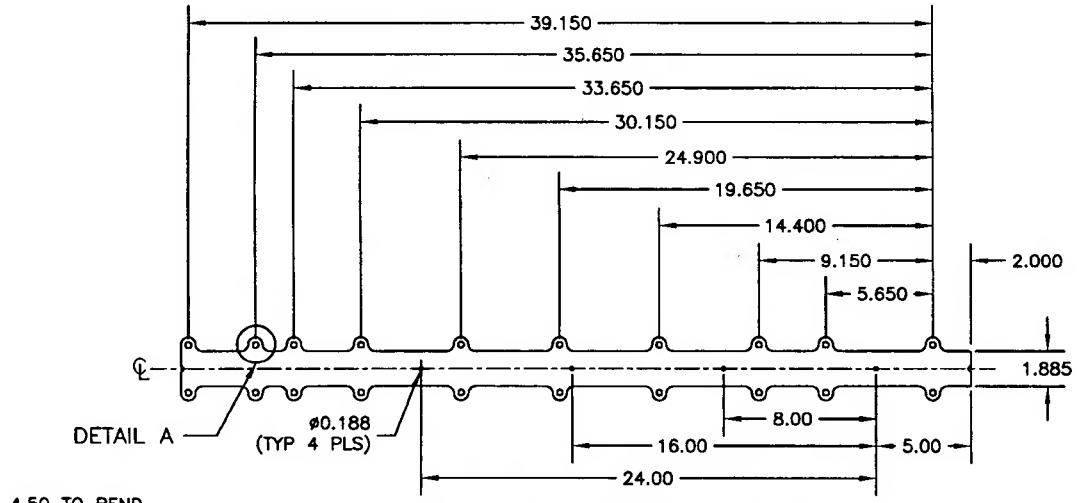
1) MATERIAL: AISI 304/316 SS SHEET, 20 GAUGE (0.038 THICK, REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
3) PART IS SYMMETRICAL ABOUT ℄
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES TO 0.010 MAX
7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
8) SEE PAGE 7 FOR DETAILS AND SECTION

RELEASED
07.02.12

DART

| DESIGN | DRAWN BY | DART AEROSPACE USA, INC. |
|---|---|---|
| CB | CB | PORT HADLOCK, WA |
| CHECKED | APPROVED | DRAWING NO. REV. |
| | | D3535 A |
| DATE | | TITLE SHEET 1 OF 7 |
| 06.10.25 | | WEARSHOE SCALE 1:10 |

| | | |
|---|---|---|
| A | 06.10.25 | NEW ISSUE |

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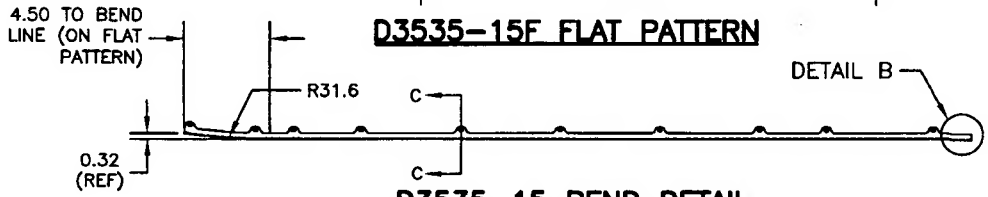


D3535-15 BEND DETAIL

07.02.12

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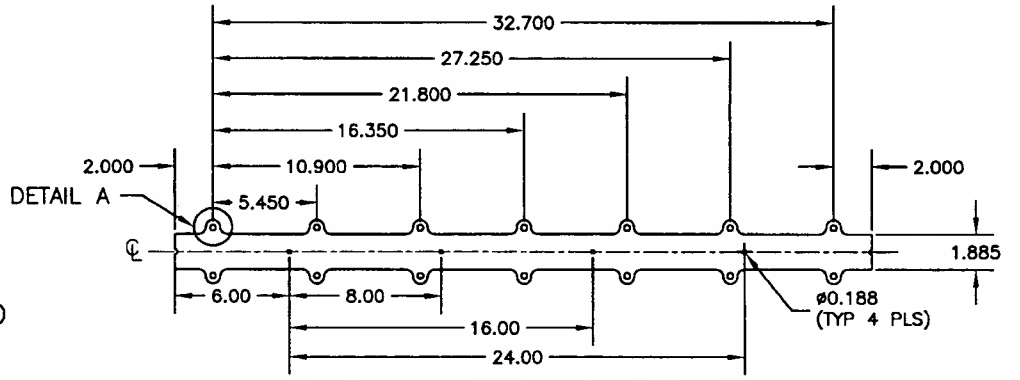
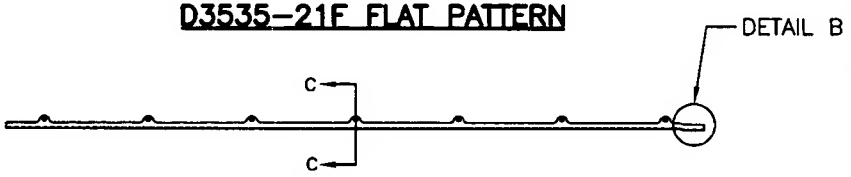



D3535-21F FLAT PATTERN




D3535-21 BEND DETAIL

**NOTES**

1) MATERIAL: AISI 304/316 SS SHEET, 20 GAUGE (0.038 THICK, REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
3) PART IS SYMMETRICAL ABOUT ℄
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES TO 0.010 MAX
7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
8) SEE PAGE 7 FOR DETAILS AND SECTION

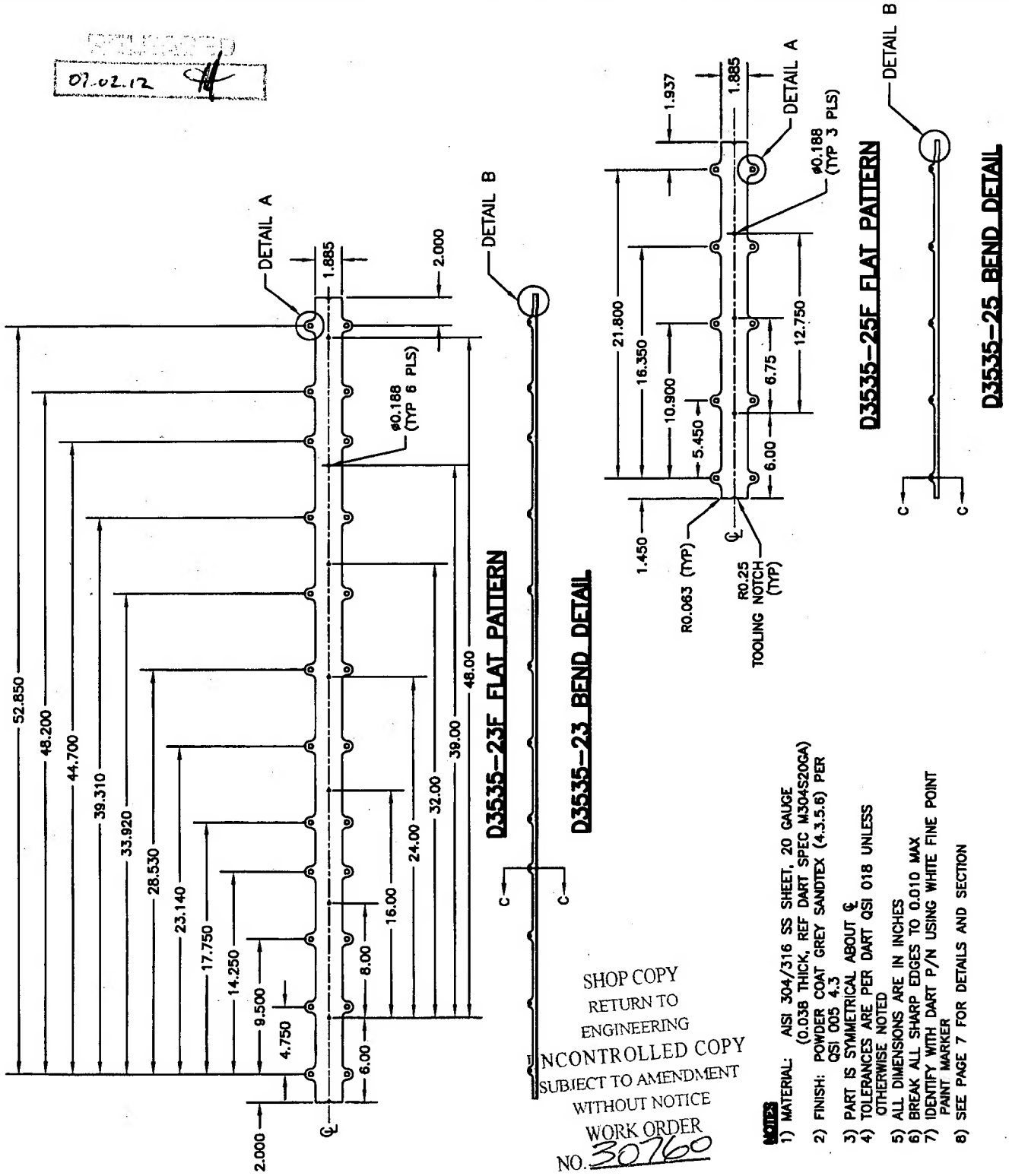
DART

| DESIGN | DRAWN BY | DART AEROSPACE USA, INC. | |
|---|---|---|---|
| C.B | C.B | PORT HADLOCK, WA | |
| CHECKED | APPROVED | DRAWING NO. | REV. A |
| DATE 06.10.25 | | TITLE WEARSHOE | SCALE 1:10 |
| | | D3535 | SHEET 2 OF 7 |

DART

| DESIGN | DRAWN BY | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
|---|---|---|---|
| CB | CB | | |
| CHECKED | APPROVED | DRAWING NO. | REV. A |
| PH | | D3535 | SHEET 3 OF 7 |
| DATE | | TITLE | SCALE |
| 06.10.25 | | WEARSHOE | 1:10 |

RELEASED
07.02.12

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NOTES
1) MATERIAL: AISI 304/316 SS SHEET, 20 GAUGE (0.038 THICK, REF DART SPEC M304S20GA)
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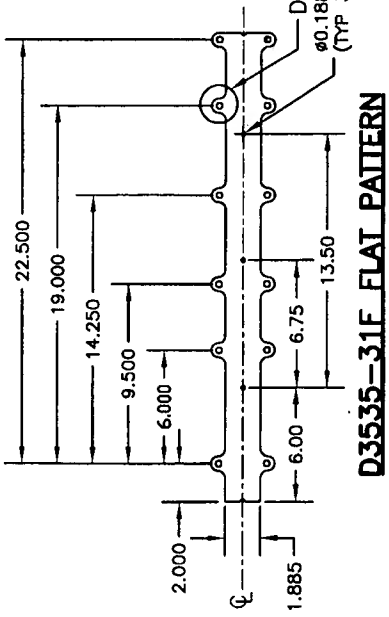
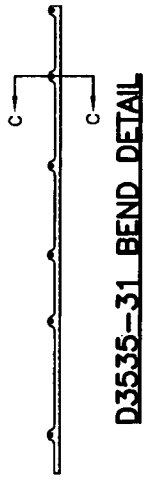
| DESIGN | DRAWN BY | DART AEROSPACE USA, INC. |
|---|---|---|
| CB | CB | PORT HADLOCK, WA |
| CHECKED | APPROVED | DRAWING NO. / REV. |
| PH | | D3535 / A |
| DATE | TITLE | SCALE |
| 06.10.25 | WEARSHOE | 1:10 |

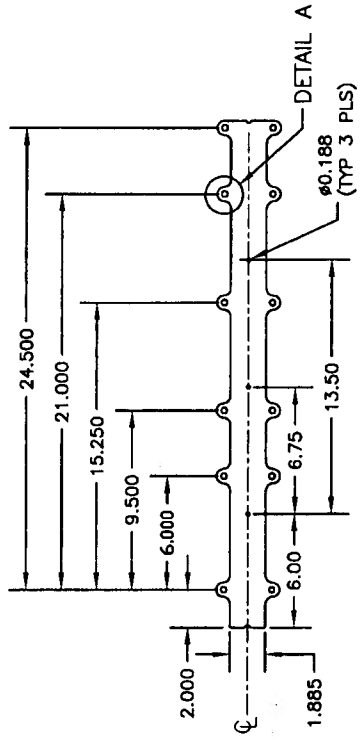
07.02.12



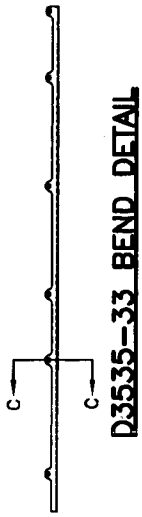

D3535-31F FLAT PATTERN




D3535-31 BEND DETAIL




D3535-33F FLAT PATTERN




D3535-33 BEND DETAIL

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**NOTES**
1) MATERIAL: AISI 304/316 SS SHEET, 20 GAUGE (0.038 THICK, REF DART SPEC M304S20GA)
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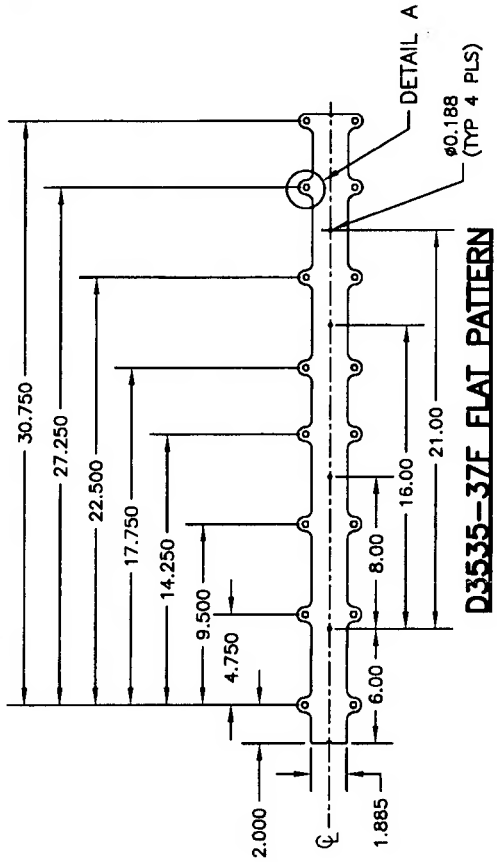
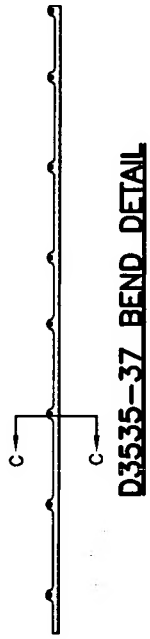
6) BREAK ALL SHARP EDGES TO 0.010 MAX
7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
8) SEE PAGE 7 FOR DETAILS AND SECTION

| DESIGN | DRAWN BY | DART AEROSPACE USA, INC. |
|---|---|---|
| CB | CB | PORT HADLOCK, WA |
| CHECKED | APPROVED | DRAWING NO. / REV. |
| AH | | D3535 / A |
| DATE | TITLE | SHEET 5 OF 7 / SCALE |
| 06.10.25 | WEARSHOE | 1:10 |

07.02.12




D3535-37F FLAT PATTERN

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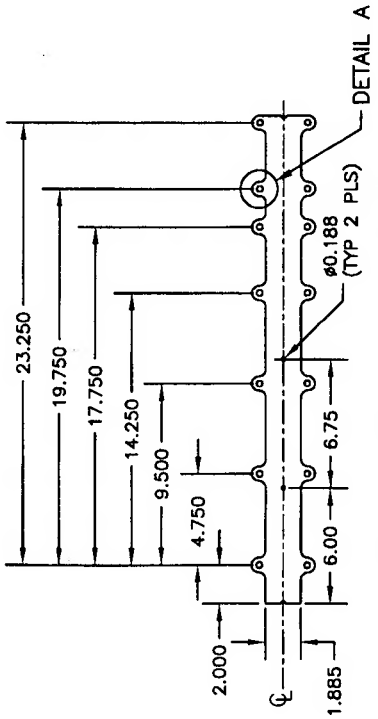


D3535-35F FLAT PATTERN


D3535-35 BEND DETAIL

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**NOTES**
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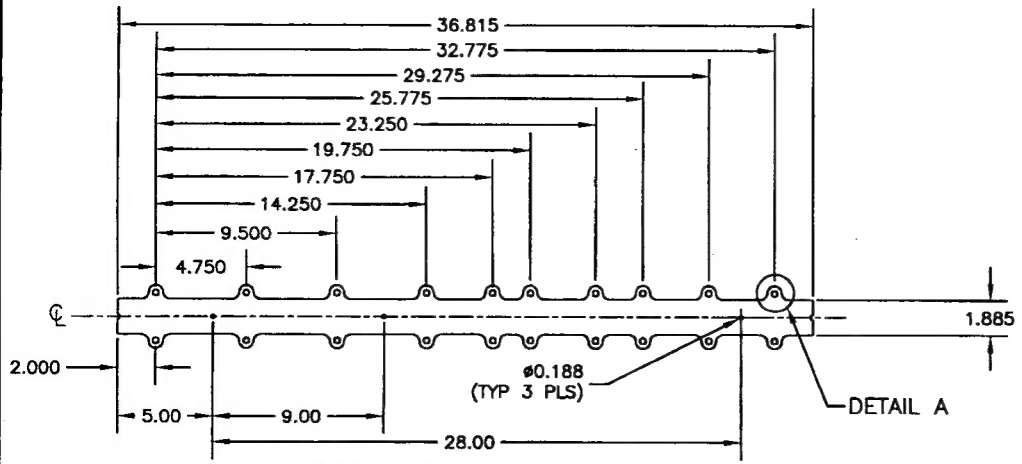
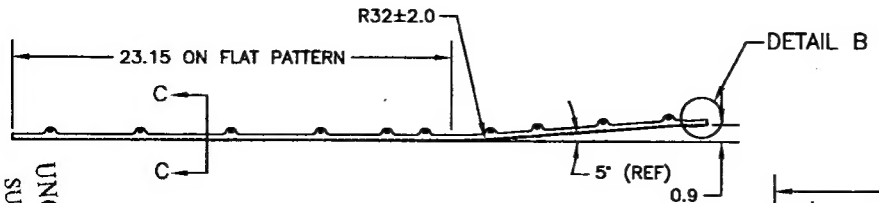



## D3535-39F FLAT PATTERN




## D3535-39 BEND DETAIL

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WORK ORDER NO. 30760

**NOTES**

1) MATERIAL: AISI 304/316 SS SHEET, 20 GAUGE (0.038 THICK, REF DART SPEC M304S20GA)
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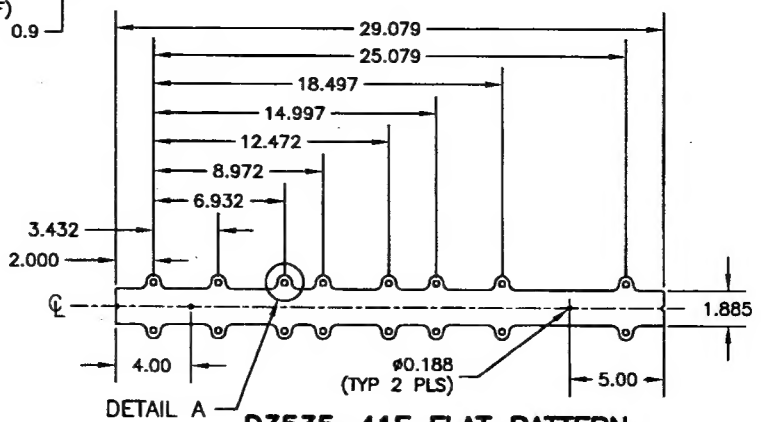
8) SEE PAGE 7 FOR DETAILS AND SECTION

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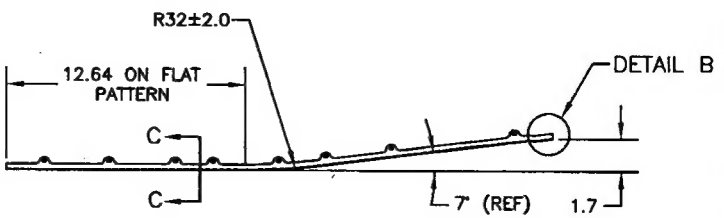



## D3535-41 BEND DETAIL

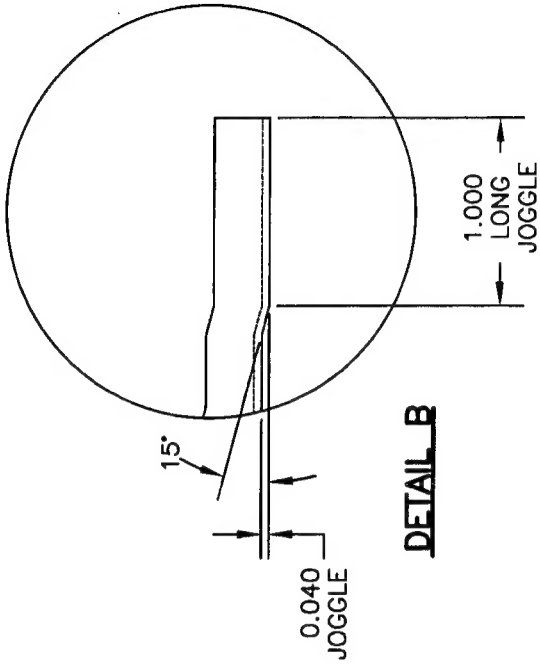
02.02.12

DART

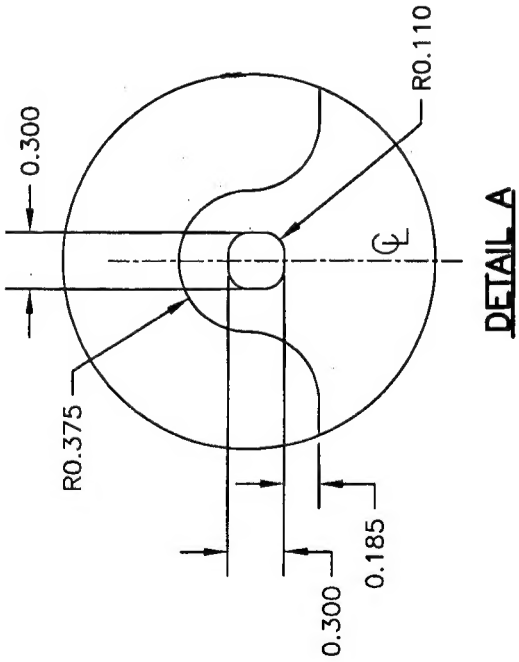
| DESIGN | DRAWN BY | DART AEROSPACE USA, INC. | |
|---|---|---|---|
| CB | CB | PORT HADLOCK, WA | |
| CHECKED | APPROVED | DRAWING NO. | REV. A |
| | | D3535 | SHEET 6 OF 7 |
| DATE | TITLE | | SCALE |
| 06.10.25 | WEARSHOE | | 1:10 |

| DESIGN | DRAWN BY | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
|---|---|---|---|
| CB | CB | | |
| CHECKED | APPROVED | DRAWING NO. | REV. A |
| PH | | D3535 | SHEET 7 OF 7 |
| DATE | | TITLE | SCALE |
| 06.10.25 | | WEARSHOE | 1:1 |

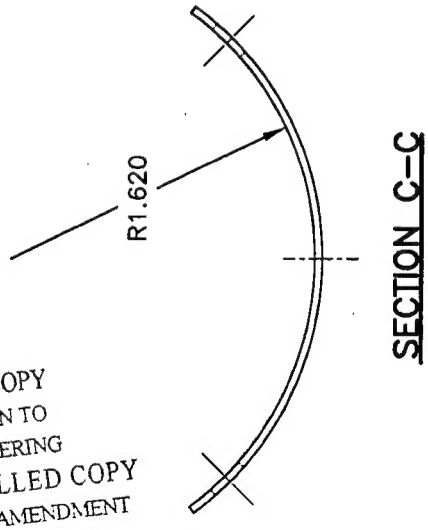
RELEASED
07.02.12




DETAIL B




DETAIL A




SECTION C–C

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WITHOUT NOTICE
WORK ORDER
NO. 30760

| DART AEROSPACE LTD | Work Order: | 30760 |
|---|---|---|
| | | |
| Description: | Part Number: | D3535 25 |
| | | |
| Inspection Dwg: , Rev: | | Page 1 of 1 |

# FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [X] Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---|---|---|---|---|---|---|
| 52.850 | +/- 0.010 | 52.850 | ✓ | | M-T | |
| 48.200 | +/- 0.010 | 48.200 | ✓ | | M-T/Vern | |
| 44.700 | +/- 0.010 | 44.700 | ✓ | | M-T | |
| 39.300 | +/- 0.010 | 39.300 | ✓ | | M-T | |
| 33.920 | +/- 0.010 | 33.920 | ✓ | | M-T/Vern | |
| 28.530 | +/- 0.010 | 28.525 | ✓ | | M-T/Vern | |
| 23.140 | +/- 0.010 | 23.140 | ✓ | | M-T Vern | |
| 17.750 | +/- 0.010 | 17.750 | ✓ | | M-T/Vern | |
| 14.250 | +/- 0.010 | 14.250 | ✓ | | M-T | |
| 9.500 | +/- 0.010 | 9.504 | ✓ | | Vern | |
| 4.750 | +/- 0.010 | 4.753 | ✓ | | Vern | |
| 2.000 | +/- 0.010 | 2.000 | ✓ | | Vertical Vern | |
| 6.00 | +/- 0.030 | 6.00 | ✓ | | Vern | |
| 8.00 | +/- 0.030 | 8.00 | ✓ | | Vern | |
| 16.00 | +/- 0.030 | 15.99 | ✓ | | Vern | |
| 24.00 | +/- 0.030 | 24.00 | ✓ | | M-T | |
| 32.00 | +/- 0.030 | 32.00 | ✓ | | M-T | |
| 39.00 | +/- 0.030 | 39.00 | ✓ | | M-T | |
| 48.00 | +/- 0.030 | 48.00 | ✓ | | M-T | |
| 2.000 | +/- 0.010 | 2.000 | ✓ | | Vertical Vern | |
| 1.885 | +/- 0.010 | 1.889 | ✓ | | Vern | |
| 0.300 | +/- 0.010 | 0.297 | ✓ | | Vern | |
| 0.300 | +/- 0.010 | 0.297 | ✓ | | Vern | |
| ~~0.938~~ | | | | | | |

| Measured by: | SAM |
|---|---|
| Date: | 07/02/25 |

| Audited by: | BC |
|---|---|
| Date: | 07.02.25 |

| Prototype Approval: | |
|---|---|
| Date: | |

| Rev | Date | Change | Revised by | Approved |
|---|---|---|---|---|
| A | | New Issue | KJ/JLM | |

| DART AEROSPACE LTD | Work Order: | 30760 |
|---|---|---|
| | | |
| Description: | Part Number: | D3535 23 |
| | | |
| Inspection Dwg: , Rev: | | Page 1 of 1 |

# FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [X] Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---|---|---|---|---|---|---|
| 0.038 | +/- 0.010 | 0.036 | ✓ | | Vern | |
| Ø0.188 | +0.005 -0.001 | 0.189 | ✓ | | Vern | |
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| Measured by: | SAD |
|---|---|
| Date: | 07/02/25 |

| Audited by: | BG |
|---|---|
| Date: | 07.02.25 |

| Prototype Approval: | |
|---|---|
| Date: | |

| Rev | Date | Change | Revised by | Approved |
|---|---|---|---|---|
| A | | New Issue | KJ/JLM | |